

## ABSTRACT OF THE DISCLOSURE

A joint structure which does not exhibit impaired joining strength induced by exposure to heat cycles and the occurrence of migration, in a ceramic heater for a glow plug or like device. A heating element 6 is embedded in a silicon nitride ceramic substrate 5. Lead wires 15 are joined to corresponding lead wire connection terminals 11, which are connected to the heating element 6 while electrical continuity is established therebetween, by use of a brazing metal 20 which contains a predominant amount of copper. The brazing metal 20 used for joining assumes the form of a brazing metal layer having a thickness of 30-400  $\mu\text{m}$ .